



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3916-041 Job Sheet 189017



Part No: D3916-041

Job Qty: 4 ea

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/15/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	4 pcs		2/15/19	0.00	1.96	Large Fab 8		
105	QC	4 pcs		2/15/19	0.00	0.00	QC5		
107	Large Fab	4 pcs		2/15/19	0.00	0.00	Large Fab 1		
110	QC	4 pcs		2/15/19	0.00	0.00	QC5		
120	QC	4 pcs		2/15/19	0.00	0.00	QC10		
130	Packaging	4 pcs		2/15/19	0.00	0.00	Packaging3 Large Fab		
140	QC21-SA	4 Ea		2/15/19	0.00	0.00	QC21		

Part Op 100 - 1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other Descriptions: lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
107 - 1- weld bushing as per dwg D3916 2- grind welds flush
130 - LOCATION: WA004-5

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3759-1	Bushing	28 pcs (7 ea)	90-Start up Operation	5115307
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	16.6640 ft (4.166 ea)	90-Start up Operation	5140974

Job Allocations

Required	Inventory	Allocated
28	259	0
17	587	0



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S149947



Part: D3916-041

Job No: 189017

Serial No/Batch: S149947

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

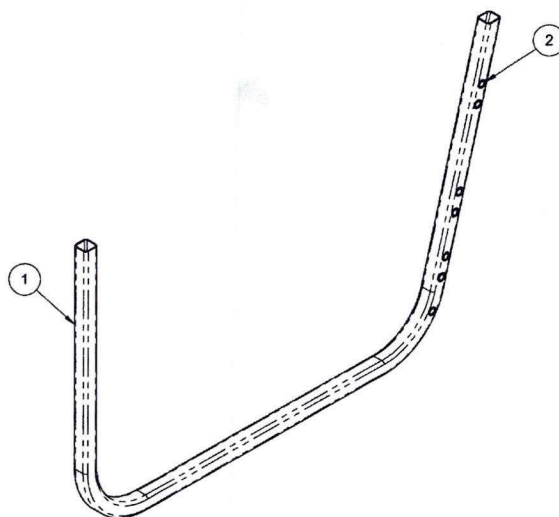
Date: 01/31/19

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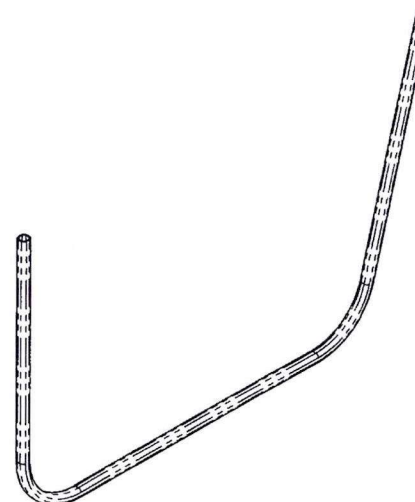
ot be found.

Plex 1/17/19 11:48 AM Dart.Macdonald.Dara

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



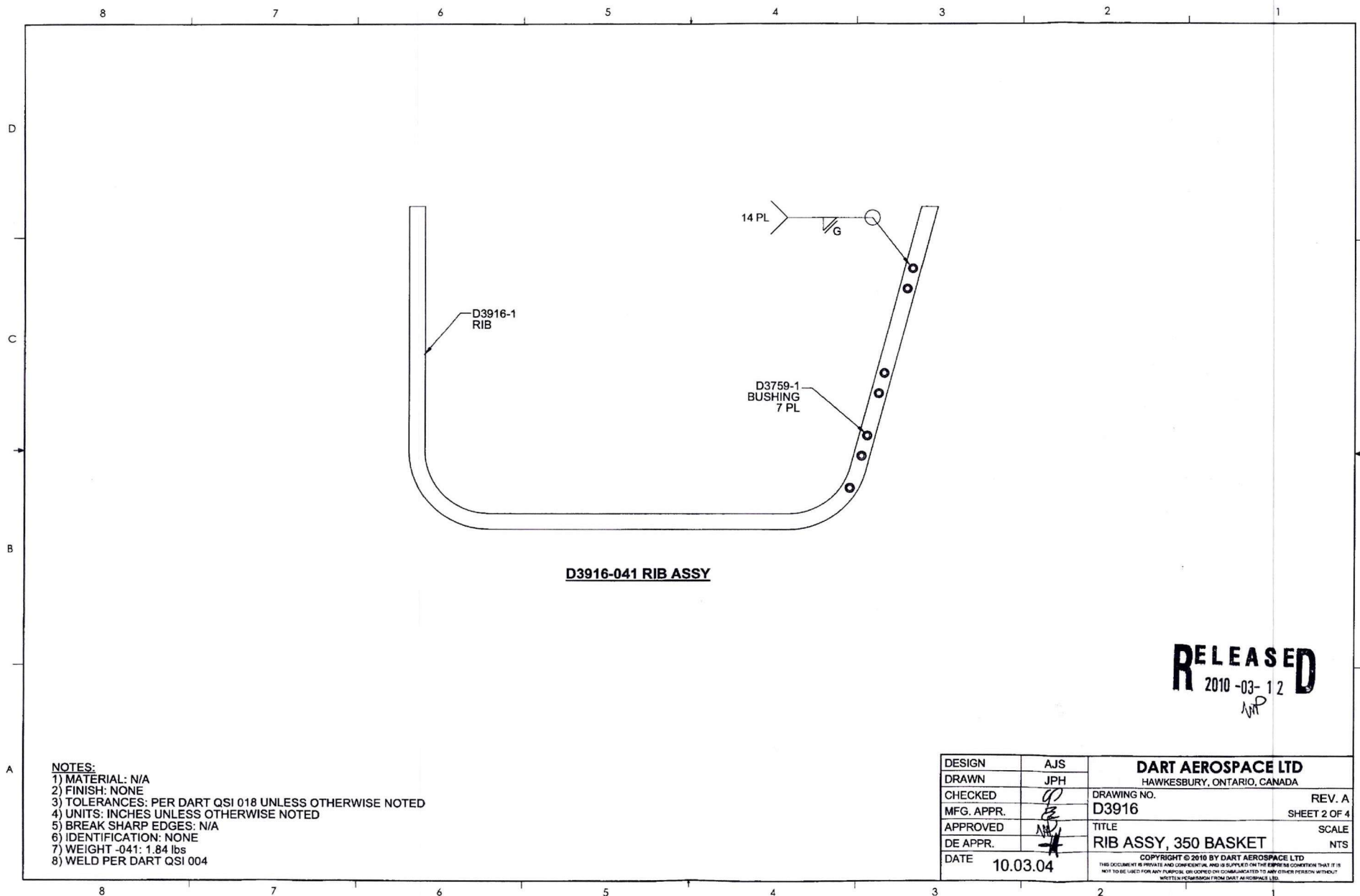
D3916-041 RIB ASSY



D3916-5 LIGHT RIB

OK 10.12.21
 UNDER REVIEW
 10.10.11
 ADDITIONAL OF HOLE & BUSHINGS
 on D3916-041-1 RIBS.
RELEASED
 2010-03-12
 JWP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3916	SHEET 1 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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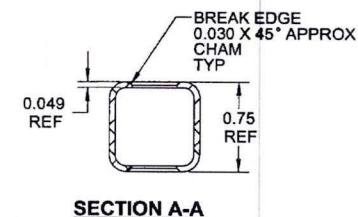
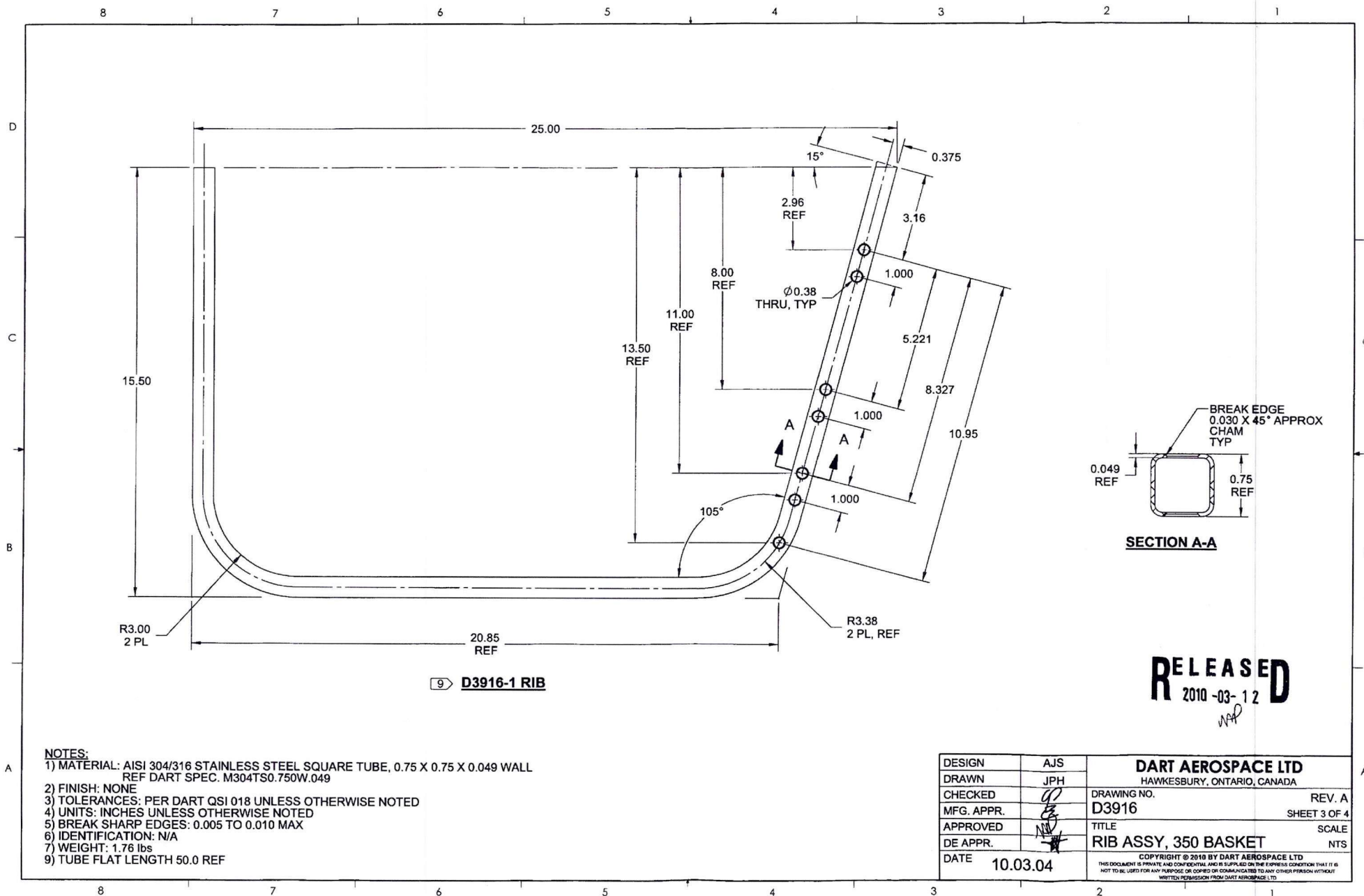


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

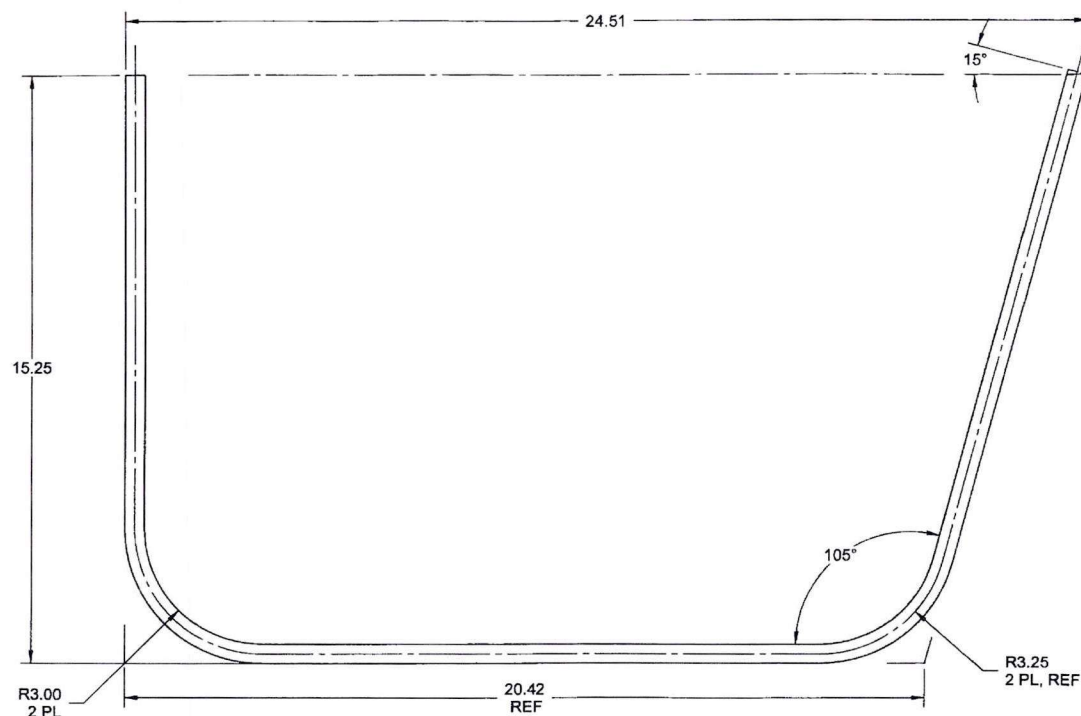
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DRAWN	JPH		
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MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
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2010-03-12
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2010-03-12
NPH

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9 D3916-5 LIGHT RIB

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

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MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					